

Date: Thursday, 01/05/2008 4:16:23 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 02.750 SUPPORT
 Job Number : 38966
 Estimate Number : 10829
 P.O. Number :
 This Issue : 01/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 38614
 Written By :
 Checked & Approved By : JLD 08.5.02
 Comment : Est: C 02.11.26 Reformat; Added P/O KJ
 est D 06.04.19 removed alodine EC
 Est Rev:E Added priming as per Rev B 07-04-30 JLM
 est F 08.03.19 Re-format EC verified by: DD

Part Number : D28931
 Drawing Number : D2893 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 15/05/2008 Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DSK078 D2893-1 TURNING DETAIL



Comment: Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)

D2893-1 TURNING DETAIL

Batch: ~~38626~~ 38131

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS 1

Machine as per Folio FA081

Tumble & Deburr

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT ALL DIM TO DIM SHEET

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask Inside Bore for Priming

START TIME:

OVEN TEMPERATURE:

10:50
400°F

M-A 08/08/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 4:16:24 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT

Job Number: 38966

Part Number: D28931

Job Number:



Seq. #:

Machine Or Operation:

Description:

FINISH TIME:

11:20

m/h

08/08/18

(20)

6.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2893 and QSI 005 4.3.

m/ 08 08 26

(10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-08-26 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

m/

08 08 28

(10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/28

Job Completion



MF 08-08-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38966
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.998	2.998	2.994
AB	0.440	0.460		0.447	0.446	0.442	0.442	0.447
AC	0.125	0.160		0.147	0.147	0.146	0.146	0.142
AD	0.040	0.060		0.049	0.049	0.049	0.049	0.048
AE	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AF	0.125	0.160		0.149	0.149	0.149	0.149	0.148
AG	0.140	0.160		0.144	0.148	0.149	0.146	0.148
AH	1.360	1.400		1.372	1.375	1.374	1.375	1.375
AI	0.040	0.060		0.050	0.050	0.049	0.049	0.050
AJ	1.190	1.230		1.214	1.216	1.216	1.217	1.217
AK	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AL	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.520	2.521	2.522	2.522	2.520
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT								
Accept/Reject								

Measured by: H.A. Date: 08/08/02

Audited by: J.L. Date: 08/08/14

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 38966
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

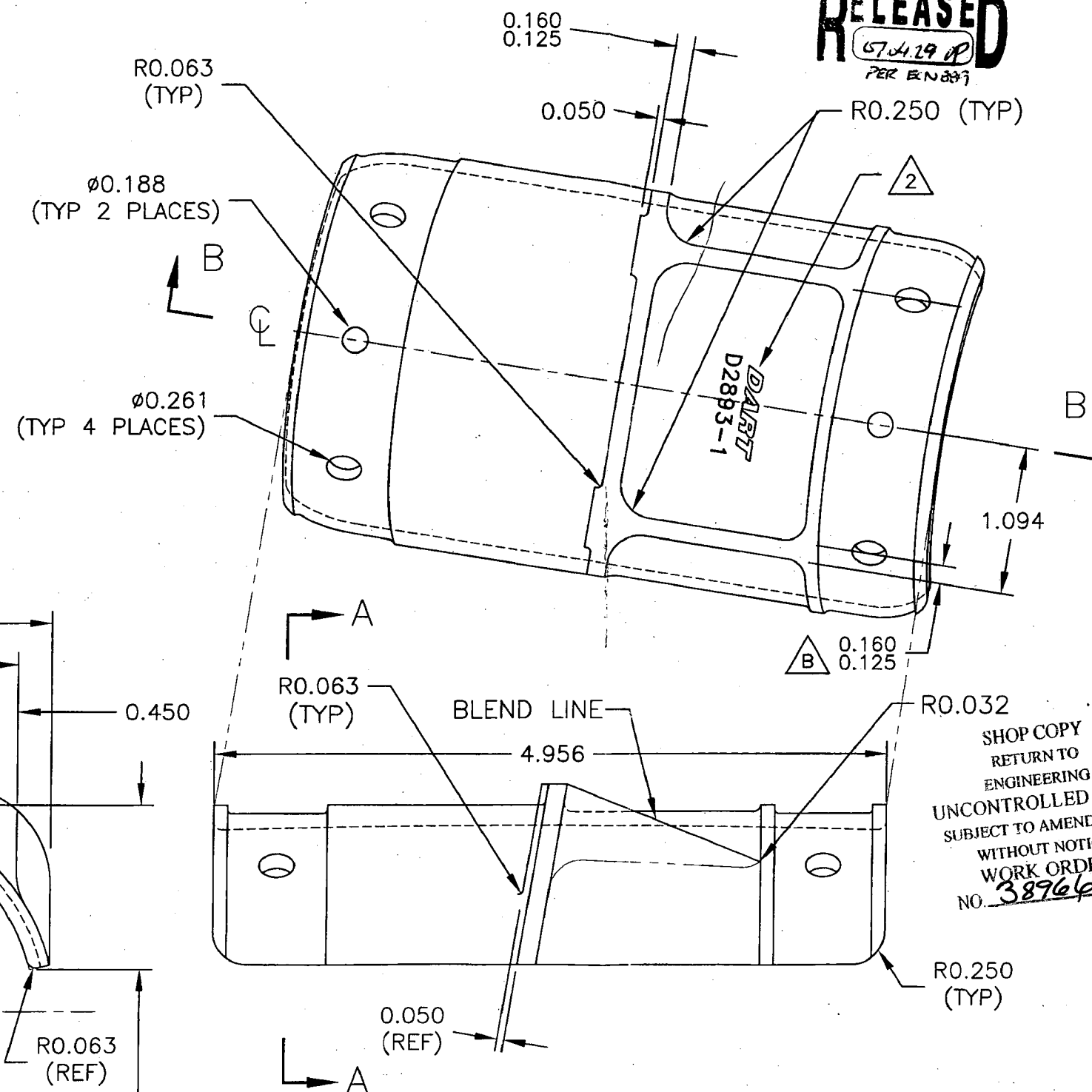
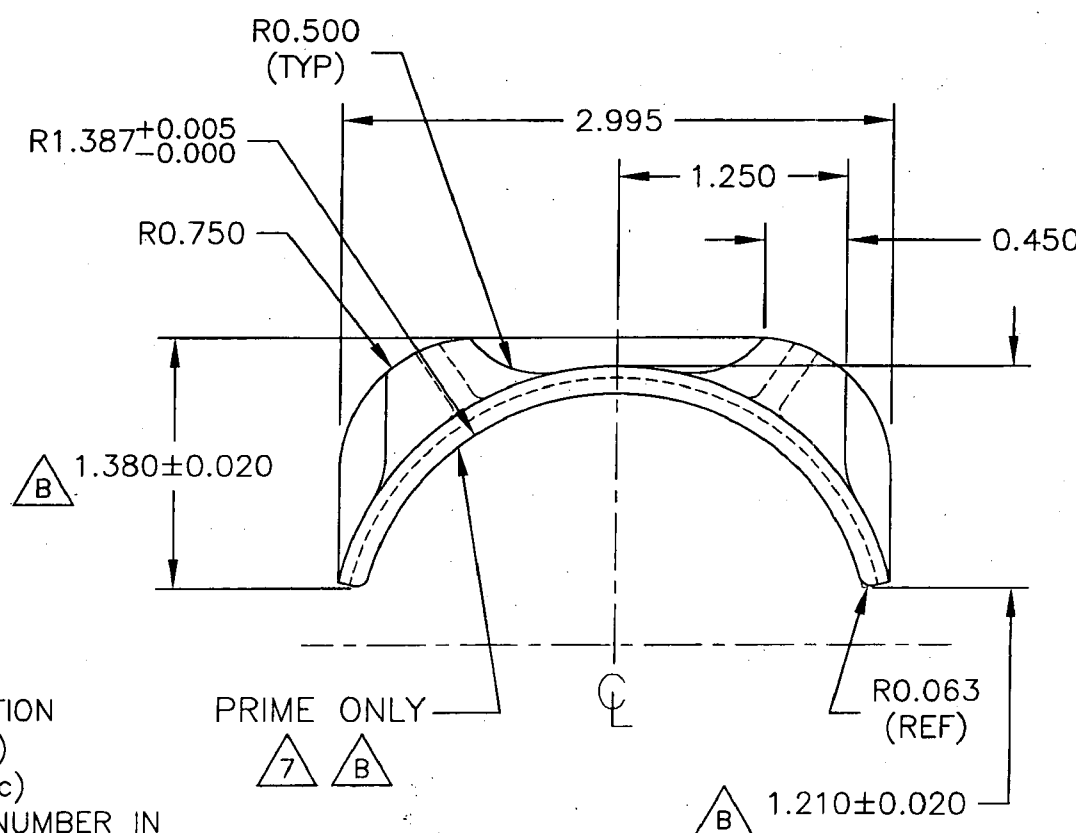
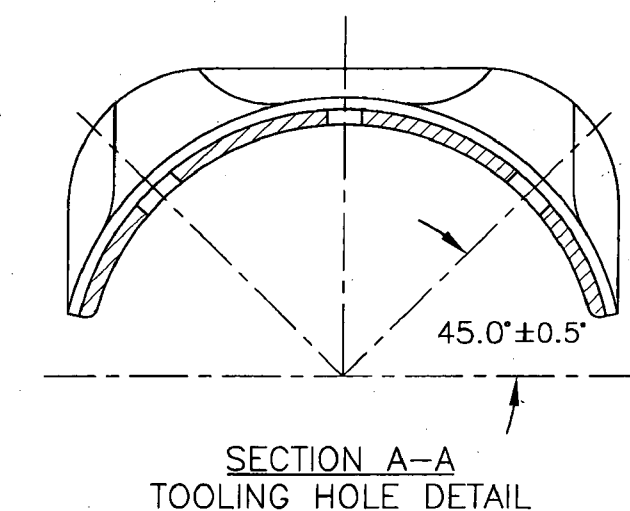
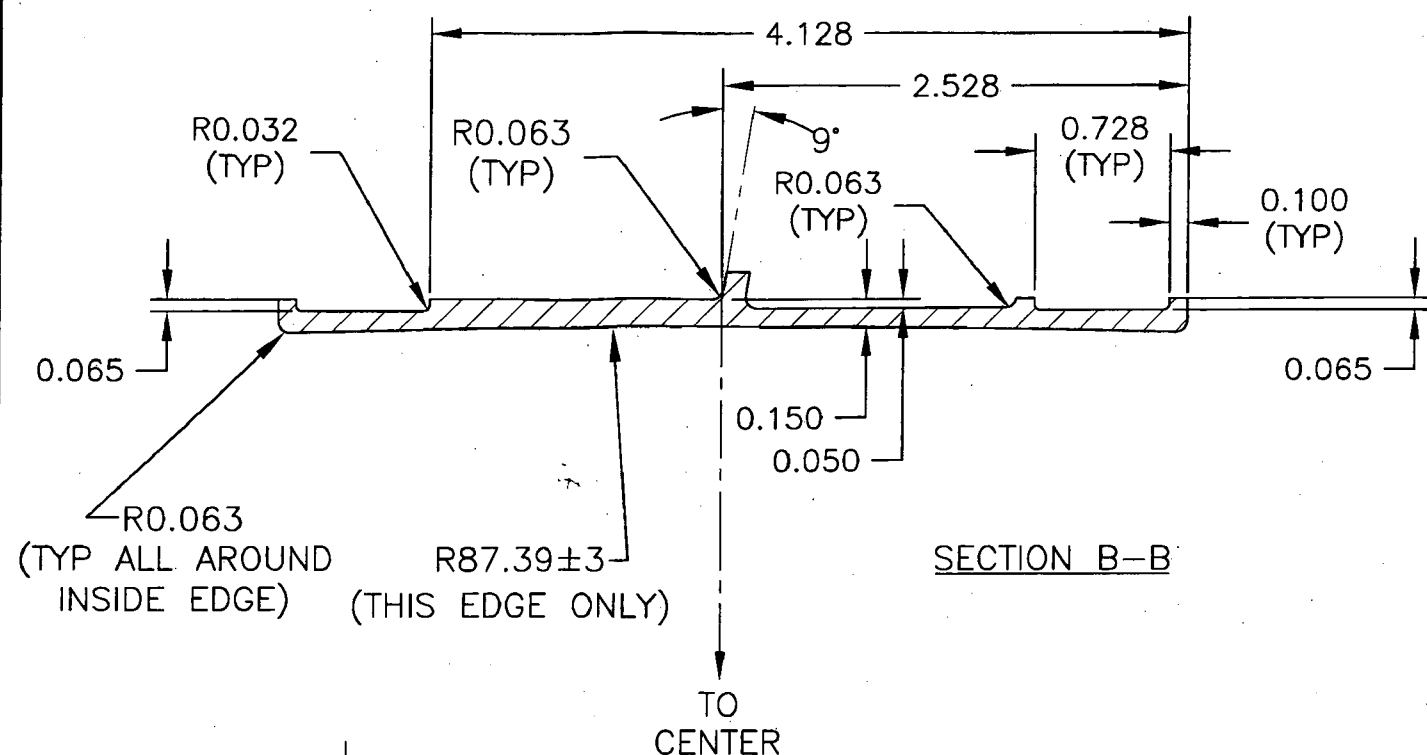
☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	2.985	3.005		2.993	2.991	2.991	2.993	2.994
AB	0.440	0.460		0.447	0.448	0.448	0.440	0.440
AC	0.125	0.160		0.140	0.149	0.149	0.142	0.142
AD	0.040	0.060		0.049	0.050	0.049	0.050	0.050
AE	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AF	0.125	0.160		0.148	0.148	0.148	0.149	0.148
AG	0.140	0.160		0.149	0.147	0.150	0.149	0.147
AH	1.360	1.400		1.372	1.372	1.373	1.374	1.375
AI	0.040	0.060		0.050	0.050	0.050	0.049	0.049
AJ	1.190	1.230		1.215	1.215	1.218	1.217	1.215
AK	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AL	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.520	2.523	2.523	2.522	2.522
AO	84.39	90.39		87.37	87.37	87.37	87.37	87.37
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT								
Accept/Reject								

Measured by: M.A	Date: 08/08/13
Audited by: J.L	Date: 08/08/14
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

RELEASED
 07.03.16
 PER EN 883



D2893-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
 HEAT TREAT TO H900 CONDITION
 (900°F FOR 1 HR, AIR COOL)
 MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN
 THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
 PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

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 PERSON WITHOUT WRITTEN PERMISSION FROM
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B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE	
A	01.01.10	NEW ISSUE	
DESIGN	QP	DRAWN BY	PH
CHECKED	TH	APPROVED	TH
DATE	07.03.16	DRAWING NO.	D2893
		TITLE	Ø2.750 SUPPORT
		REV. B	SHEET 1 OF 1
		SCALE	1:1

DART

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 HAWKESBURY, ONTARIO, CANADA

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